

Work Order ID 126339***126339***

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Tuesday, May 30, 2017 7:53:23 AM

Item ID: D350-600-241 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod™ Fwd Opening LH AS350
Start Date: 11/4/2014 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 11/28/2014 Req'd Qty: 1.00 ***1*** Customer:
Reference: ECN 14-594-ECN not completed-stays at CHG001

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9639	A								
DSI9701	A								
IIN-D350-600	E								

220

0.00

220

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK D350-600-241 X 1 B101404

REWORK PER DSI 9701

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

rework not done
now obsolete

LL 17-05-30

Work Order ID 126339

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126339

Page 2

Item ID: D350-600-241 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: **Stop *NS2***
Item Name: Spacepod™ Fwd Opening LH AS350
Start Date: 11/4/2014 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 11/28/2014 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference: ECN 14-594-ECN not completed-stays at CHG001

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Identify as per dwg & Stock Location: _____	0.00							
240									
Packaging	Memo	0.00							
Packaging	ID AND STOCK UNDER NEW BATCH NUMBER @ CHG 002								
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									


W
17-05-30

Picklist Print

Page 1

Tuesday, May 30, 2017 7:53:21 AM

Work Order ID: 126339

126339

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS350

Start Date: 11/4/2014

Required Date: 11/28/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.03.07 new issue ec
 IPP rev B 07.04.16 reformat,D3188 revE ec IPP Rev:C
 remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D
 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified
 by: DD IPP Rev:E remove seq 130/140 now all in seq
 150 DD 10.05.13 verf
 :EC IPP REV:F
 13.02.06 AS PER DSI9639 REV.A DD VERF:JLM IPP REV:G 14.07.30
 as per DSI9701 rev.a DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D350-600-241

Manufactured No

Each 3.0000

1

D350-600-241

Spacepod™ Fwd Opening LH AS350

Location

Loc Qty

Loc Code

fg070

3

101404

1

105062

1

70175

1

D5127-1

Manufactured No

Each 17.0000

2

D5127-1

Shim, Large

Location

Loc Qty

Loc Code

ST153

17

128839

17

D5127-3

Manufactured No

Each 17.0000

2

D5127-3

Shim, Small

Location

Loc Qty

Loc Code

ST153

17

128941

17

REPRINT

Work Order ID 101404

101404

Page 1

April-01-14 9:08:01 AM

Item ID: D350-600-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00 *1*

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9639	A

100 0.00
100
QC
Quality Control
Memo
PULL FROM STOCK D350-600-241 X 1 B#64739

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 4K7 TEL: 1-813-632-5200			
P/N	D350-600-241	CHG	CHG001
DESC	Spacepod LH	STC	SH93-88
LOT	B64739	STC	SR00098NY
MODEL	AS350	STC	SR00099NY
MADE IN CANADA			

110 0.00
110
Small Fab
Small Fab
Memo
DISASSEMBLE ALL HARDWARE AND DISCARD ALL NUTS, BOLTS & WASHERS
USE AIR Discard any used hardware
SCUFF LIGHTLY AND REPRIME

120 0.00
120
QC
Quality Control
Memo
QCS- Inspect part completeness to step on W/O

DAS
27
9-09
14/4/15

41 14-04-01 (x1)
P40

DQA: AK Date: 14/05/02



QA Closed: AK Date: 14/4/30

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>101404</u> Part No. <u>D350-600 241</u> NCR No. <u>14-3777</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☒ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material	<u>14/4/15</u>	<u>110</u>	<u>1</u>	<u>re assemble using original hardware replace missing hardware</u>	<u>S</u>	<u>D2464 neoprene seal</u> <u>B 110770</u> <u>MS 21042402 nut</u> <u>B 125445 x2</u> <u>NA51515H3 washer</u> <u>B 128635 x2</u> <u>3568-1 decal</u> <u>B 48254 x1</u> <u>AN96050 8/NA11490418325</u> <u>B 127813 x4 washer</u> <u>MS 27039-08-11 screw</u> <u>B 122441 x2</u>	<u>AK</u> <u>14-04-15</u>	<u>SHD</u> <u>14/4/15</u>	<u>S</u> <u>14/04/15</u> <u>D2464</u>
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☒ Other
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re - work / missing form
AK Revise Pile/it

Work Order ID 101404

April-01-14 9:08:01 AM

101404

Page 2

Item ID: D350-600-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00

1

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Wing Walk as per dwg QSI005 4.4 Batch 128623 0.00***130***

HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

140 QC3- Inspect Part Finish 0.00

140

QC

Memo

0.00

Quality Control

150 0.00

150

Small Fab

Memo

0.00

Small Fab

RE-ASSEMBLE USING ORIGINAL D-PARTS AND NEW HARDWARE

14-04-15 (r1)14-04-1514-04-15

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Item ID: D350-600-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00 ***1***

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			
161 *161* Packaging Packaging	Pick Kit Memo	0.00 0.00							
162 *162* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							

APR 22 2014

DAS
31
9-89

APR 22 2014

DAS
06
9-89

Work Order ID 101404***101404***

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Item ID: D350-600-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/10/13 Req'd Qty: 1.00

1

Customer: CU-DAR001

Reference: RMA RA111508

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>151</u>	0.00							
170									
Packaging	Memo	0.00	LAG						
Packaging			13						
			9-39		APR 24 2014				
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14-4-2514-4-24

Picklist Print

Page 1

April-01-14 9:08:01 AM

Work Order ID: 101404

101404

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.03.07 new issue ec
IPP rev B 07.04.16 reformat,D3188 revE ec IPP Rev:C
remove D3188-1m add D3188-5 DD 10.04.07 verified by:JLM IPP rev D
10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified
by: DD IPP Rev:E remove seq 130/140 now all in seq
150 DD 10.05.13 verf
:EC IPP REV:F
13.02.06 AS PER DSI9639 REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2985		Manufactured	No				Each	21.0000		1			
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D2985

Label												DAS	
-------	--	--	--	--	--	--	--	--	--	--	--	-----	--

DAS
06
9-89LocationLoc QtyLoc Code

ST022

21

104987

9

106718

9

86719

3

DAS
31
9-89

D350-600-241

Manufactured No

D350-600-241

Spacepod™ Fwd Opening LH AS 350

Each

1.0000

1

64739

14-04-15

LocationLoc QtyLoc Code

FG118

1

70175

1

D350-600-449

Manufactured No

D350-600-449

Switch Relocation

Each

1.0000

1

106720

LocationLoc QtyLoc Code

FG125

1

105758

1

DAS
06
9-89DAS
31
9-89

Picklist Print

Page 2

April-01-14 9:08:01 AM

Work Order ID: 101404

101404

Parent Item: D350-600-241

D350-600-241

Parent Item Name: Spacepod™ Fwd Opening LH AS 350

Start Date: 5/09/13

Required Date: 5/10/13

Start Qty: 1.00

Required Qty: 1.00

K10021

Manufactured No

Each

2.0000

**

K10021

Spacepod Hardware (-241)

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG125

2

97225

2

1

Winda

D30871 x1

B 59334

DAS
31
9-89

DAS
06
9-89

April-01-14 9:08:01 AM

Shop Packet Print

Page 2

Work Order ID 64738

December 14, 2010 1:13:31 PM



Page 1

Item ID: D350-600-241

Accept



Setup Start



Revision ID:

Item Name: Spacepod, LH, AS350

Stop



Start Date: 12/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/07/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

U

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D350-600-241
CHG 001

MA 11 02 08
ck for ch 11/02/08

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D350-600-141	CHG	CHG003
DESC	Spacepod LH	STC	SH93-88
LOT	B33436	STC	SR00098NY
MODEL	AS350	STC	SR00099NY
MADE IN CANADA			

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Page 2

Item ID: D350-600-241

Accept



Setup Start



Revision ID:

Item Name: Spacepod, LH, AS350

Stop



Start Date: 12/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/07/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------



Small Fab

Small Fab

Memo

PULL FROM STOCK:
1 X D350-600-141 B 33436
REWORK TO MAKE D350-600-241
PER IIN-D350-600 REV.E
SECTION 3.4

Epocast SD-A1 B115154
Hysol 9309.3 B115680
milled Fiber m100859

0.00

0.00

ET 10-12-17



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/2101

40

Work Order ID 64738

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Item ID: D350-600-241

Accept



Setup Start



Revision ID:

Item Name: Spacepod, LH, AS350

Stop



Start Date: 12/14/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/07/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170	Wing Walk as per dwg QSI005 4.4 Batch <u>115790</u>	0.00							
-----	---	------	--	--	--	--	--	--	--



HandFinish

Memo

0.00

Hand Finishing

PT

11-02-01

180	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--



QC

Memo

0.00

Quality Control

11/02/01

1

4

185	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--



Packaging

Memo

0.00

Packaging

VERIFY KIT TO ENSURE ALL PARTS ARE INCLUDED FOR -241
ENSURE ORIGINAL K10021 KIT IS UP TO DATE

11/2/9 SP

K10021

66260

11/2/9 SP

350-600-449

59211

SP

Work Order ID 64738

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Page 4

Item ID: D350-600-241

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacepod, LH, AS350

Start Date: 12/14/10 Start Qty: 1.00

Required Date: 1/07/11 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC4- 100% Inspect kits for completeness Memo VERIFY KIT TO ENSURE ALL PARTS ARE INCLUDED FOR -241 ENSURE ORIGINAL K10021 KIT IS UP TO DATE	0.00 0.00				<i>11</i>	<i>02</i>	<i>08</i>	<i>17</i>
200  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo REPACKAGE PER PPP USING NEW B/N & P/N NEW LABELS & PAPERWORK REQ'D Identify and pack for shipping as per PPP D350-600-141 Location: _____ PPP rev: <i>B</i>	0.00 0.00							<i>11/2/10</i>
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/2/10</i>

Picklist Print

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Page 1

Work Order ID: 64738

Parent Item: D350-600-241

Parent Item Name: Spacepod, LH, AS350



Start Date: 12/14/10

Required Date: 1/07/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A 07.03.07 new issue ec
 IPP rev B 07.04.16 reformat, D3188 rev E ec IPP Rev: C
 remove D3188-1m add D3188-5 DD 10.04.07 verified by: JLM IPP rev D
 10.04.19 removed hardware at seq 190 duplicated on K10021 EC verified
 by: DD IPP Rev: E remove seq 130/140 now all in seq
 150 DD 10.05.13 verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-600-141 		Manufactured	No				Each	3.0000		1			
Spacepod, LH, AS350												10-12-17	

Location	Loc Qty	Loc Code
FG117	3	
33436	1	
35070	1	
43215	1	

D350-600-249 		Manufactured	No				Each	3.0000		1			
Spacepod Upgrade												10-12-17	

64932

Location	Loc Qty	Loc Code
FG033	3	
48153	1	
64274	2	

FG-778150-550-ROL 		Purchased	No				sf	1,739.150		1			
7781 9oz Glass 50"x125yd												10-12-17	

Location	Loc Qty	Loc Code
ST404	1739.15	
108932	18	
111166	397	
113905	1324.15	

+1